Date: Tuesday, 12/18/2007 10:54:50 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 36415		
Estimate Number	: 12901		
P.O. Number	: N/A	Part Number	: D350811
This Issue	: 12/18/2007 S.O. No. : N/A	Drawing Number	: D3508 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/18/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 33011	Material	: N/A
Written By	:	Due Date	: 1/20/2008 Qty: 10 Um: Each
Checked & Approved By	: 07.12.18		
Comment	: Est Rev:A New Issue 07.06.12 EC Est Rev:B Rev C dwg 07-12-06 DD		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet

7.4172

Comment: Qty.: 0.6181 sf(s)/Unit Total : 6.1814 sf(s)
304SS .038" THK (20GA)
(M304S20GA)
Batch: 106702 HB 8-1-8

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3508
Dwg Rev: C HB 8-18
Prog Rev: C (12)

2-Deburr if necessary HB 8-1-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-1-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 08/01/08 (+12) counts

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 08/01/08 (12)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 08/02/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:54:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARPLATE

Job Number: 36415 **Part Number:** D350811

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/01/08 (XU)
7.0	POWDER COATING	POWDER COATING
	M 105642	(RX)
	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	M-L 08/01/09
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	HD	
	Comment: INSPECT POWDER COAT	08-01-09 (X12)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-15	HD 08-01-09 (X12)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(12) 08/01/11

Job Completion

08.01.11

Form: rprocess

Dart Aerospace Ltd

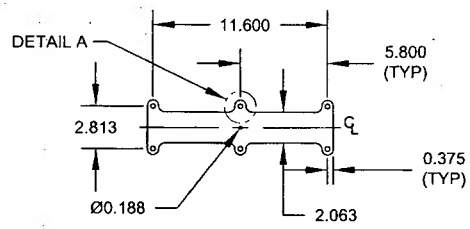
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

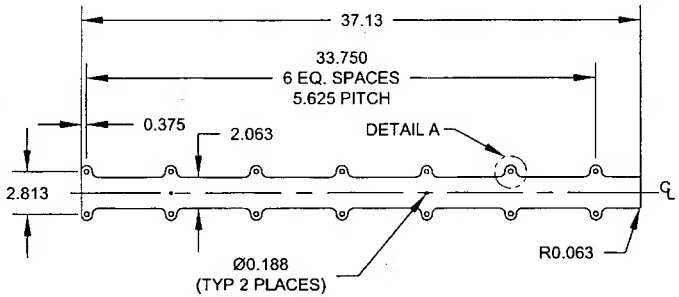
QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

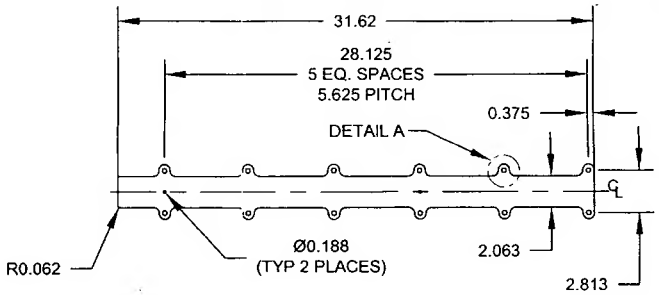
NOTE: Date & initial all entries



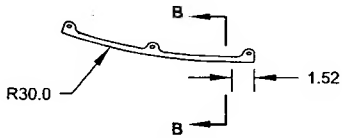
D3508-1 FLAT PATTERN



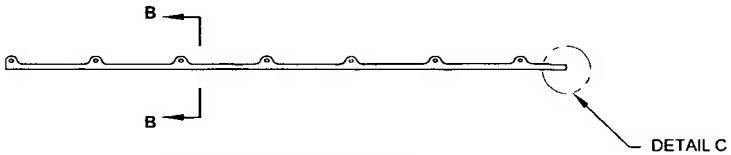
D3508-3 FLAT PATTERN



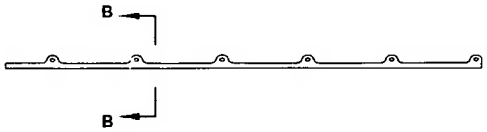
D3508-5 FLAT PATTERN



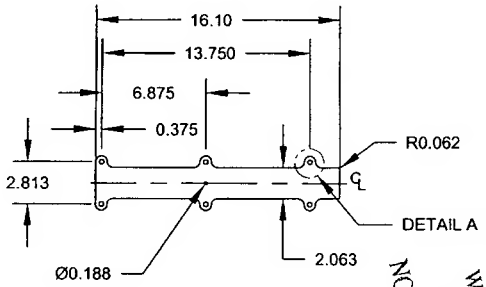
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



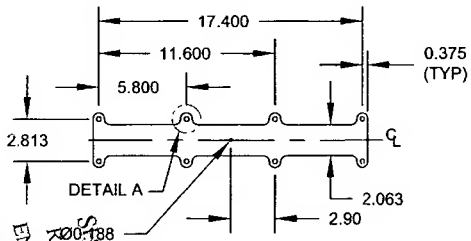
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



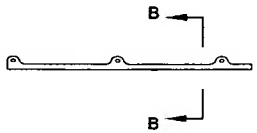
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)



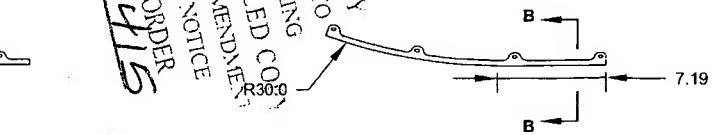
D3508-7F FLAT PATTERN



D3508-9F FLAT PATTERN



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

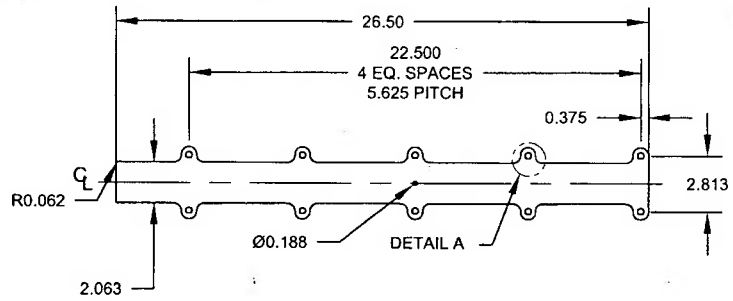
NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) WELD PER DART QSI 004
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.015
7) IDENTIFICATION: NONE
8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs D3508-13 - 0.25 lbs

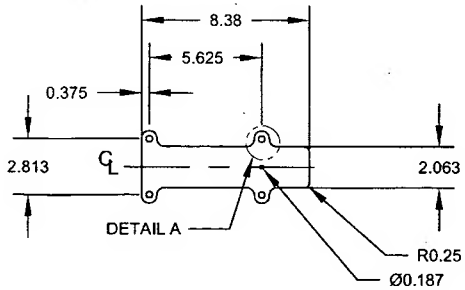
RELEASED 07.11.16

REV.	DESCRIPTION	BY	DATE
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21

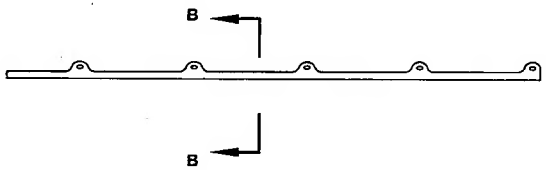
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20		



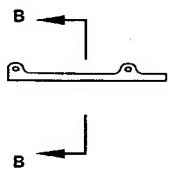
D3508-11F FLAT PATTERN



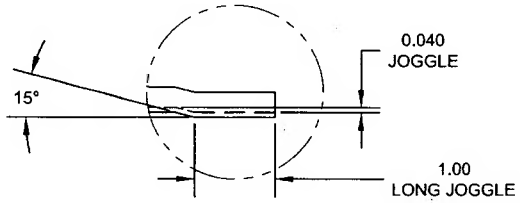
D3508-13F FLAT PATTERN



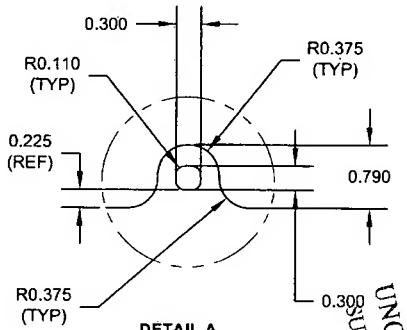
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



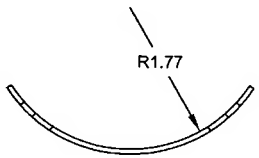
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



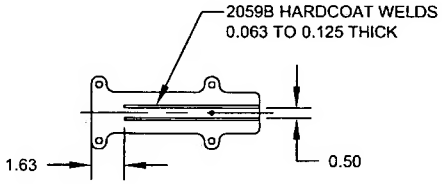
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
WORK ORDER
NO. 36415

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D3508 — REV. C — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE: WEARPLATE — SCALE 1:6
DE APPR.		
DATE	07.04.20	

DART AEROSPACE LTD	Work Order:	36415
Description: WEAR PLATE	Part Number:	D3508-11
Inspection Dwg: D3508-11 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+.005 -.001	.193	X			
.300	+/- .010	.304	X			
.300	+/- .010	.304	X			
2.063	+/- .010	2.064	X			
2.813	+/- .010	2.813	X			
.375	+/- .010	.375	X			
22.500	+/- .010	22.500	X			
26.50	+/- .030	26.50	X			
5.50	+/- .030	5.50	X			

Measured by:	JB	Audited by:		Prototype Approval:	N/A
Date:	8-1-8	Date:	08/01/08	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	